QC

Quality Control

98604

ARAP

Page 1

Friday, March 15, 2013 8:49:23 AM Item ID: D4005-041 Accept *N900040100* **Revision ID:** Item Name: Fwd Floor Gutter **Start Date:** 3/15/2013 Start Qty: 5.00 **Cust Item ID:** Required Date: 3/22/2013 Req'd Qty: 5.00 **Customer:** Reference: Run Date: 19-3-8 Tooling: Process Plan: VM **Approvals:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Accept Reject Reject Insp. Work Center ID **Description Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D4005 В 100 0.00 *100* 13.03.15 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg (D4005-13) Dwg Rev: 3 Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110*

0.00

Memo

NCR: Ye	es / No				WORK ORDER NON-	CONF	ORN	MANCE / UP	DATE			
					·					QA Closed:	Dat	te:
Work Orde	ŕ:				DISPOSITION				_	EPARTMENT		
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DQA:

Date:

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0.00

0.00

Insp.

Page 2

QC5- Inspect part completeness to step on W/O 0.00 0.00 Memo

Memo

Bend D4005-13 as per Dwg

130 Brake NC

140

Quality Control

Brake NC

140

N	CR	. \	es .	/	Nο
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WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	fute	Date:(3/04 <i>1</i>	n.	,
Classed.	-1/		12/2		

										QA Closed:	Date:	13/3/20
Work Order	•	6	186	04		DISPOSITION			AGAINST D	EPARTMENT	/PROCESS	· (1
Part No	o. 1	40	05	- 04	!]	Rework Scrap Use-as-is Work Order Update	Th	۱ erm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		ĺ			Descri	ption of work order update	Initia	1	Action	Sign &		
Cause	Di	ite	Step	Qty	1	or Non-conformance	Chief E	ng	Description	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator					Oly 41 Point	Dart Scrape in wong Drafti	OAS 16		Scrap + Desty	0AS 16 3-5	AS 27 9 C)	OAS 16
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Supplier Training Unapproved									At 13/15/10			
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	Tur	ning S	equence	!		Finish	Out	of S	Sequence			
	Wa	/e/Tw	ist in Tul	be		Folio	Out	side	Dimensions			

Page 3

N900040100

Setup Start

Cust Item ID:

Customer:

Tool ID

Date: Date: Tooling:

SPC (Y/N):

Accept

Date: Date: Run

Start

Sequence ID/ **Work Center ID** Operation Description

Set Up/ **Run Hours**

Tool # Plan Code Accept Qty

Reject Reject Qty

13-03-15

Stop

Insp. Number Stamp

141

141

Large Fab Large Fab

Memo

0.00

1- Weld D4003-13 tube to angle as per dwg D4005

2- grind flush as per dwg

Weld per dwg A/R Aluminum rod Batch: 10854

142

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

143

QC5- Inspect part completeness to step on W/O

0.00

1/12

Quality Control

Memo

											DQA:	Date	2: ,
NCR:	⁄es	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UP	DATE	QA Closed:	Date	· ·
						DISPOSITION				AGAINST DE			
Work Orde	er:					DISPOSITION _	_			Adamsi be		_	
						Rework	╛		Skid-tube	Crosstube		Water Jet	Engineering
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						Use-as-is	1	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.					Work Order Update	_		Large Fab	Composite]	Supplier	
Root					Descri	ption of work order update	Τ	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Cr	nief Eng	Desc	cription	Date	Verification	QC Inspector
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Operator													
Material									-				
Setup													
Other	Ш		ļ										
Process						•			<u> </u>	•			
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Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

98604

Friday, March 15, 2013 8:49:23 AM Item ID: D4005-041 Accept **Revision ID:** Fwd Floor Gutter Item Name: Start Date: 3/15/2013 Start Qty: 5.00 Required Date: 3/22/2013 Req'd Oty: 5.00 Reference: Approvals: **Process Plan:** Date: Tooling: QC: Date: SPC (Y/N): Sequence ID/ Operation Set Up/ Work Center ID Description **Run Hours** 150 Chemical Conversion Coat per QSI005 4.1 0.00 *150* HandFinish 0.00 Memo Hand Finishing 155 QC7-Inspect Chemical Conversion Coat 0.00 QC 0.00 Memo Quality Control 160 Gloss Grey (4.3.5.15) per QSI 005 4.3 0.00 *160* Powdercoat Start Time: / 32, 0 F Powder Coating Finish Time:

Page 4 *N900040100* Setup Start Cust Item ID: **Customer:** Run Date: Stop Date: Tool ID Tool # Plan Accept Reject Reject Insp. Qty Qty Code Number Stamp 4 20013319

4X8.Mf 13/3/19

4xx m-f 13/03/20

m122066

NCR: Y	es	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UPC	DATE			
											QA Closed:	Date:	
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Cause		Date	Step	Qty	•	or Non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							- AUI	LT CATE	GORY	<u></u>			
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		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in n Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete tions Incomplete/U enance eled	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
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Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord Friday, March		9:23 AM		*986	304*						Page 5
Item ID: Revision ID: Item Name:	D4005-041 Fwd Floor Gu	itter	· · · · · · · · · · · · · · · · · · ·	Accept	*N900	040)*	Setup Star Stop	t *N	S1*
Start Date: Required Date Reference:	3/15/2013	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item I Customer:	D:			Stop	' *N	S2*
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate: ate:		I	Run Star Stop	!/	R1* R2*
Sequence ID/ Work Center	ID	Operation Description QC3- Inspect Part Finish	<u></u>	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 QC Quality Control		Memo		0.00				4 4		Jel is	luzk

0.00

0.00

0.00

Identify as per dwg & Stock Location: \$\infty 25\big| 0.00

Memo

Memo

QC21- Final Inspection - Work Order Release

190

200

190 Packaging

200

Quality Control

Packaging

Page 5

413-32/

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER	NON-COI	NFORM	AANCE / UP	DATE	QA Closed:	 Date:	
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Part N	_					work Scrap		Skid-tube Machining	Crosstube Small Fab	Dro	d. Eng. Coor.	Engineering Quality
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Cause	Date	Step	Qty		or Non-conformance	- Cr	nief Eng	Desc	cription	Date	verification	QC Inspector
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	Cuffs				Contamination	_	Mainte		_	Part Moved		
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	Ripples i			-	Drill Holes	<u> </u>	Offset	- til	• •			
	—— i	Naves in I		n	Drawing		4	Calibration				
	Turning :	Sequence)		Finish		Out of S	Sequence				

Wave/Twist in Tube

· Picklist Print

Friday, March 15, 2013 8:49:22 AM

Work Order ID:

98604

Parent Item:

D4005-041

Parent Item Name:

Fwd Floor Gutter

Start Date: 3/15/2013

Required Date: 3/22/2013

Start Qty: 5.00

Required Oty: 5.00

Comments:

IPP rev A 10.01.21 new issue Prelim EC verified by:DD

IPP Rev:B 10.05.03 as per ECN10-

425

562 DD verified by:EC IPP Rev:C 12.03.07 as per dwg rev.b DD verf: EC

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit Total	Otv	Date Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure		Qty	Qty Issued	Issued
D4003-13		Manufactured	No	è o	7.0	141	Each	0.0000	1 [4] 5		13-13-19
Fwd Fuel Gutter Line M6061T6S.040			N	178	609				U	Λ	BL
6061-T6 .040 Sheet		Purchased	No			100	sf	698.7156	0.42 2.210526	- WI	13.03.15
				Location		Loc Qty	Lo	e Code	·		
				MAT021		698.7156			<u></u>		
				1210)99	273.7156					

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NCR: Ye	es / No				WC	ORK ORDER NON-C	ON	VFORM	/IANCE / UP	PDATE	QA Closed	d: Da	te:	٠ ،
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Part No						Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet od. Eng. Coor. ore/Packaging Supplier		Engineering Quality Other
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Root Cause	Date	Step	Qty	Desc	-	of work order update n-conformance	1	nitial ief Eng		ction cription	Sign & Date	Verification	n	QC Inspector
occ/Data quip/Tooling Operator Material Setup Other Process Supplier Fraining Jnapproved														
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	Ripples in Torque W	Vaves in 8		,	Draw	ving	F	₹	Calibration Sequence					

Wave/Twist in Tube

DART AEROSPACE LTD	Work Order:	98604
Description: Angle	Part Number:	D4005-13
Description: Angle	rait Number.	D4005-13
Inspection Dwg: D4005 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+0.006/-0.001	0.376	/		VerN	MM-01
1.67	+/-0.030	1.668			1/2/11	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,
26.77	+/-0.030	26.77	/		MT	MM. 02
4.00	+/-0.030	3.994	/		Value	
1.25	+/-0.030	1.25	/		UWN	
2.22	+/-0.030	2.233	V		VESN	
2.26	+/-0.030	2.766			very	
1.87	+/-0.030	1.840	/		VWN	
3.70	+/-0.030	3.71	V,		Very	
4.12	+/-0.030	4.12			Vers	_
9.08	+/-0.030	9.08	1		MT	Mall 02
9.13	+/-0.030	9.13			MT	
0.040	+/-0.010	0.039	/		ven	
		 				
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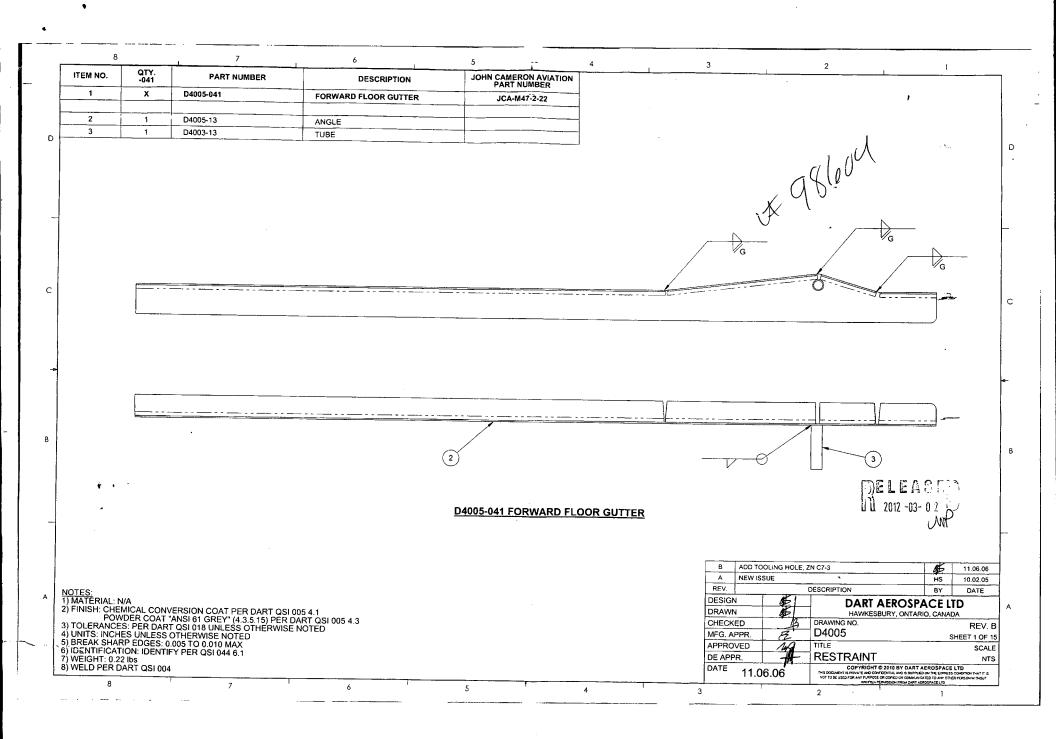
Measured by:	Mul	Audited by:	Preliminary Approval:	N/A
Date:	13.03.15	Date: 13-03-15	Date:	N/A

Rev	Date	Change		Revise	d b	у	Approved
Α	10.08.03	New Issue	P/O D4005-041	KJ ⁽	KI		A
					77		

NCR:	Yes	1	No

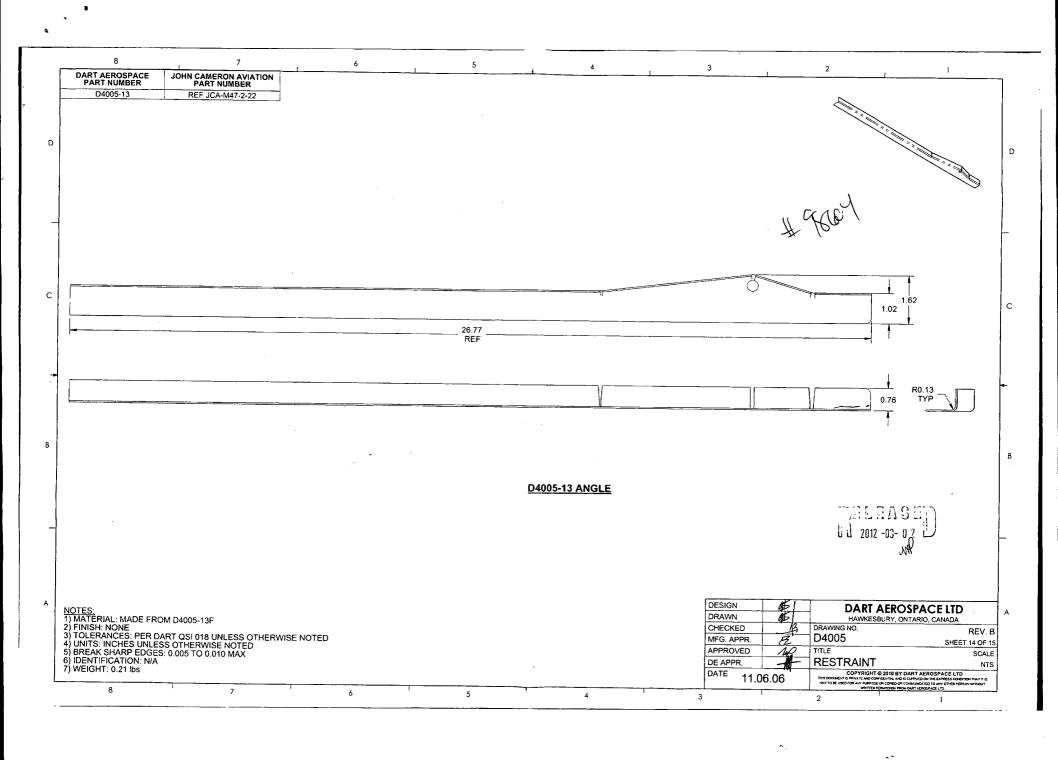
										DQA:	Date:	
NCR: Ye	es / No				WORK ORDER NON-CONFORMANCE / UPDATE							
										QA Closed:	Date:	
Work Orde	r:				DISPOSITION				AGAINST D	EPÄRTMENT	PROCESS	
Part No					Scrap Machining Small Fab. Use-as-is Thermoforming Finishing		Crosstube Small Fab Finishing Composite	- ∤	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root				Descri	ption of work order update		nitial	Act	ion	Sign &		ı
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Equip/Tooling						İ						
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	Bending			_	Bend	\vdash	Grain		<u> </u>	Ovalized	_	Pressure/Forced
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-	Cracks				Broken/Damaged	\vdash	4	ion Incomplete	-	Part Incorred		Weld
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	Inspectio		Tube	-	Cut Too Short	<u> </u>	Misread	t .		Power Loss/	Surge	Other
]	Ripples in			<u> </u>	Drill Holes	-	Offset					
ļ	Torque W			n ,	Drawing	<u> </u>	4	Calibration				*
	Turning S	•			Finish	\vdash	-1	Sequence				
l	Wave/Tw	ist in Tul	be	i	Folio		Outside Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



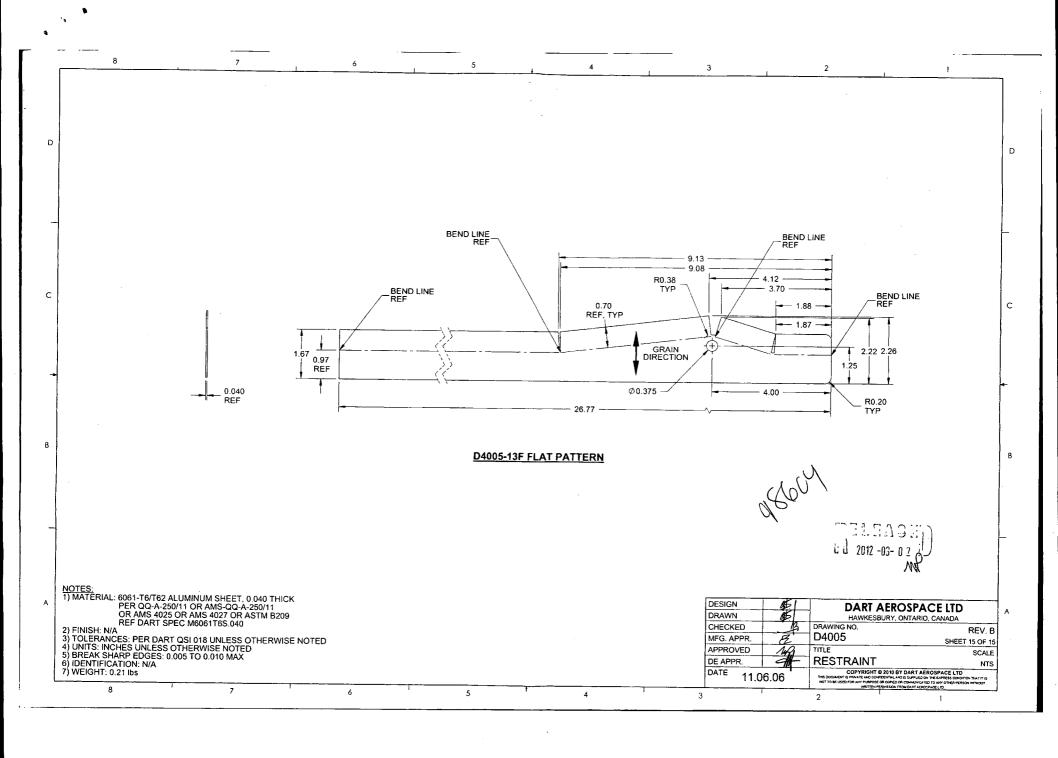
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NCR: Y	es / No				WORK ORDER NON-C	D-4-						
							QA Closed:	Date	:			
Work Orde	ř:				DISPOSITION			AGAINST	DEF	PARTMENT	PROCESS	
	-				Rework	1 I		Skid-tube Crosstube		Water Jet Engineering		
Part N	0.				Scrap	1		Machining Small Fab		Pro	d. Eng. Coor.	Quality
					Use-as-is	1 -	Therm	noforming Finishing		Rec/Stor	e/Packaging	Other
NCR N	o				Work Order Update]		Large Fab Composite			Supplier	
Root			<u> </u>		ption of work order update	1	tial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Description	\blacksquare	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling	_											
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	Crushed/Crimped				Burrs	\vdash	•	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
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Ţ	Heat Trea	at			Countersink	\square	/lislabe	eled		Positioned V	Vrong	
Ī	Inspectio	n Strip in	Tube		Cut Too Short	\square v	/lisread	. ·		Power Loss/	Surge	Other
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Ī	Torque V	Vaves in E	Extrusio	n	Drawing	o	ot of C	Calibration				
Ī	Turning 9	Sequence			Finish		Out of Sequence					

Wave/Twist in Tube



												DQA:	Dat	e:	
NCR: Y	es / No					WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:									
					_		_				-	QA Closed:	Dat	e.	<u> </u>
Work Orde	ŕ:				Ì	DISPOSITION				AGAINST [DEP	PARTMENT	/PROCESS		
Part No.						Rework Scrap Use-as-is		. 1	Skid-tube Crosstube Machining Small Fab			Water Jet Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other
NCR N	lo					Work Order Update]		noforming Large Fab	Finishing Composite		Rec/3tol	Supplier		Other
Root				Desc	rip	tion of work order update	П	nitial	Act	tion		Sign &			
Cause	Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	1	QC Inspector
oc/Data quip/Tooling Derator Material etup Other Process upplier raining															
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							AUL	T CATE	GORY						
Landir [ng Gear			Г	_	General		۱		Г	_	.	Г		la <i>(</i> = ,
	Bending Centre Not Concentric to O/S Cracks					Bend BOM/Route Broken/Damaged		Grain Hardware Inspection Incomplete				Ovalized Over/Under tolerance Part Incorrect			Pressure/Forced Temperature/Cure Weld
	Crushed/Crimped					Burrs	Г	Instruct	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
Ī	Cuffs					Contamination		Mainte	enance	Γ		Part Moved	•		
	Heat Tr	eat				Countersink		Mislabe	eled			Positioned V	Vrong		
	Inspect	ion Strip in	Tube			Cut Too Short		Misread	t			Power Loss/	Surge		Other
	Ripples	in Bend		ľ		Drill Holes		Offset		_					
	Torque	Waves in	Extrusio	n [Drawing		Out of 0	Calibration		•				
1	Turning Sequence					Finish		Out of Sequence							

Wave/Twist in Tube



NCR: Y	$oldsymbol{\cdot}$															
										QA Closed:	Date	<u> </u>				
Work Orde	Order: DISPOSITION							AGAINST DEPARTMENT/PROCESS								
Part No.					Rework Scrap		Skid-tube Crosstube Machining Small Fab				Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other				
NCR N	o				Use-as-is Work Order Update	[†] '"		oforming Large Fab	Finishing Composite	Rec/stoi	Supplier					
Root		-		Descri	ption of work order update	Initia	al	Act	ion	Sign &						
Cause	Date	Step	Qty	1	or Non-conformance	Chief E	Eng	Descr	iption	Date	Verification	QC Inspector				
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Landin	ng Gear				General	_				_	_					
	Bending				Bend	Gra	ain		<u> </u>	Ovalized	L	Pressure/Forced				
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Har	dwar	re		Over/Under	tolerance	Temperature/Cure				
ļ	Cracks	Cracks Broken/Damaged		Insp	pectio	on Incomplete		Part Incorre	it L	Weld						
	Crushed/	Crushed/Crimped Burrs		Burrs	Inst	tructi	ons Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled					
	Cuffs				Contamination	Ma	inte	nance		Part Moved	•					
	Heat Treat				Countersink	Mis	label	ed		Positioned V	Vrong	'				
	Inspectio	n Strip in	Tube		Cut Too Short	Mis	read			Power Loss/	Surge	Other				
	Ripples in	n Bend			Drill Holes	Off	set									
	Torque V	Vaves in I	Extrusio	n \lceil	Drawing	Out	t of C	alibration								
	Turning 9	Sequence)	Γ	Finish	Out	t of S	equence								
	Wave/Twist in Tube Folio				Folio	Out	tside	Dimensions								

Date: